

Work Order ID 57720

April 14, 2010 10:18:26 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 14/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: RLDate: 10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: M09213

SL 10/04/20 (1x)PD 10.04.20

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PL 10.04.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 57720

April 14, 2010 10:18:26 AM



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| | | | | | |
|--------------------------------|-----------------|--|---------------|-------|--|
| Item ID: D2989-043 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Basket Lid Assembly | | | | | |
| Start Date: 14/04/2010 | Start Qty: 1.00 | | Cust Item ID: | | |
| Required Date: 22/04/2010 | Req'd Qty: 1.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------------|-------------|------------------|-------------|-----|-------|--|
| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|------------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 130 | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 | | | | | | | |
| | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

pressure wash
M 114207

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT
START TIME: 11:15am
OVEN TEMPERATURE: 400°F
FINISH TIME: 11:45am
***** 2nd coat if necessary *****
2ND COAT:
START TIME: 12:00pm
OVEN TEMPERATURE: 400°F
FINISH TIME: 12:30pm

⇒ M 10/04/20

ⓧ

1 ⓧ

| W/O: | | WORK ORDER CHANGES | | | | | |
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Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 10/04/22 @

150

Identify as per dwg & Stock Location: *6-A*

0.00



Packaging

W/O 57718

Memo

0.00

Packaging

EP 10/04/22 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/26
MMF
10-4-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:18:31 AM

Page 1

Work Order ID: 57720

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 7.0000 1.0000



Rib



PD 10.04.14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

7

57182

7

①

D2989-3 Manufactured No 100 Each 0.0000 1.0000



Rib



B57420 PD 10.04.15

D2989-4 Manufactured No 100 Each 0.0000 1.0000



Rib



B57421 PD 10.04.15

D2989-5 Manufactured No 100 Each 2.0000 2.0000



Rib



PD 10.04.15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

2

57419

2

②

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Page 2

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 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3182-1 Manufactured No 100 Each 2.0000 2.0000



Hinge



PD 10.04.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

2

57341

2

✓ D3442-3 Manufactured No 100 Each 18.0000 2.0000



Shim



PD 10.04.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

18

53137

4

56204

14

✓ D3827-041 Manufactured No 100 Each 2.0000 1.0000



Rib Assembly (Inboard)



PD 10.04.14

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

2

55982

2

April 14, 2010 10:18:31 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 57720

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Parent Item Name: Basket Lid Assembly


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 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3832-5 Manufactured No 100 Each 5.0000 1.0000

 Mesh (Lid)

SY 10/04/20

Warehouse Loc Qty Loc Code

Location


Main Warehouse

WA 5

56084 2

57603 3

2 1x

✓ D3833-5 Manufactured No 100 Each 15.0000 2.0000

 Mesh (Lid End)

B53722 Qx
SY 10/04/20

Warehouse Loc Qty Loc Code


Location

Main Warehouse


WA 15

51305 2

53722 13

✓ D3838-041 Manufactured No 100 Each 0.0000 1.0000

 Rib Assembly (Basket Lid, LH)

B57422 PD 10.04.15

✓ D3838-042 Manufactured No 100 Each 0.0000 1.0000

 Rib Assembly (Basket Lid, RH)

B57423 PD 10.04.15

April 14, 2010 10:18:31 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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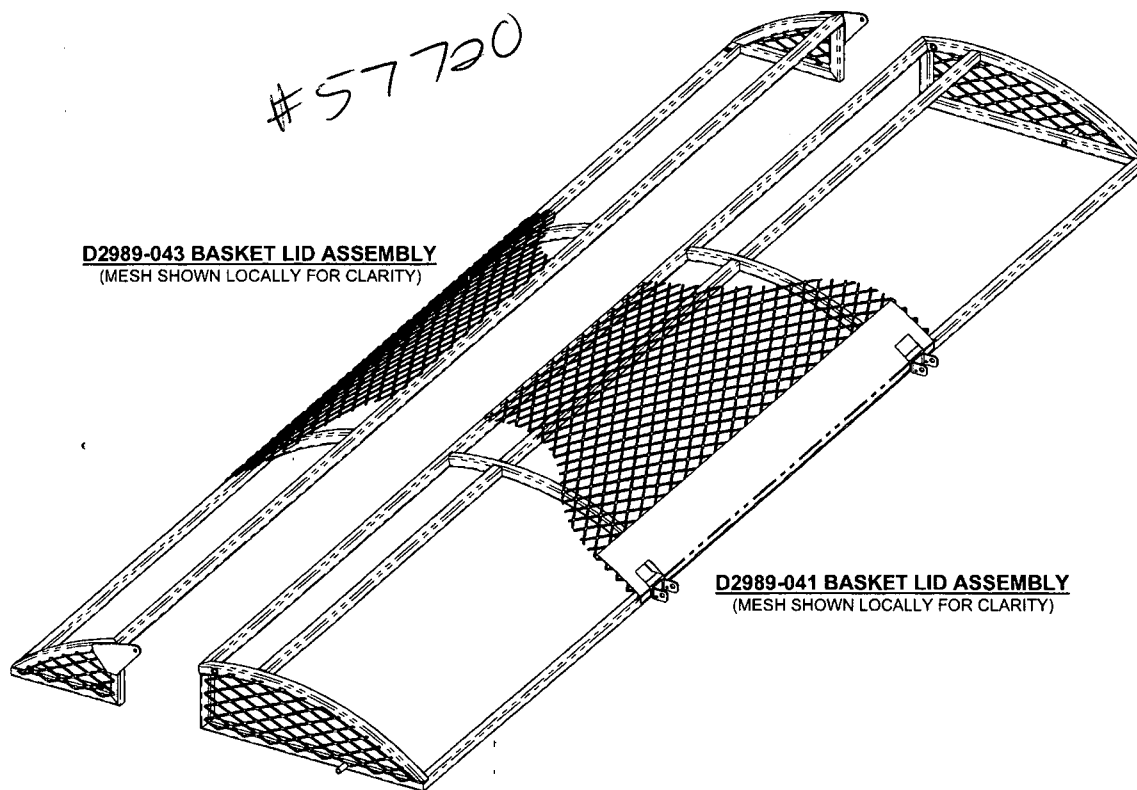
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NOTE: Date & initial all entries

#57720

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

△

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D2989-041 | BASKET LID ASSEMBLY |
| 2 | | X | D2989-043 | BASKET LID ASSEMBLY |
| 3 | 1 | | D2506 | LABEL PLATE |
| 4 | 1 | | D2512-7 | RIB |
| 5 | 2 | | D2581 | MOUNTING BRACKET |
| 6 | | 1 | D2989-3 | RIB |
| 7 | | 1 | D2989-4 | RIB |
| 8 | | 2 | D2989-5 | RIB |
| 9 | 2 | | D2989-13 | RIB |
| 10 | 2 | 1 | D2989-17 | RIB |
| 11 | 2 | | D2989-19 | RIB |
| 12 | | 2 | D3182-1 | HINGE |
| 13 | | 2 | D3442-3 | SHIM |
| 14 | | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 15 | 1 | | D3832-3 | MESH, BASKET LID |
| 16 | | 1 | D3832-5 | MESH, BASKET LID |
| 17 | 2 | | D3833-3 | MESH, LID END |
| 18 | | 2 | D3833-5 | MESH, LID END |
| 19 | 1 | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 20 | 1 | | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 21 | | 1 | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 22 | | 1 | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 23 | 1 | | D3852-041 | RIB ASSEMBLY |
| 24 | 1 | | D3852-042 | RIB ASSEMBLY |

RELEASED
08/11/18

| | | | |
|------------|---|---|--------------|
| D | REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-11/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM | MB | 08.09.24 |
| C | FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD | AJS | 08.05.20 |
| B | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | PH | 05.06.07 |
| A | NEW ISSUE | DS | 00.10.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 1 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY | NTS |
| DATE | 08.09.24 | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

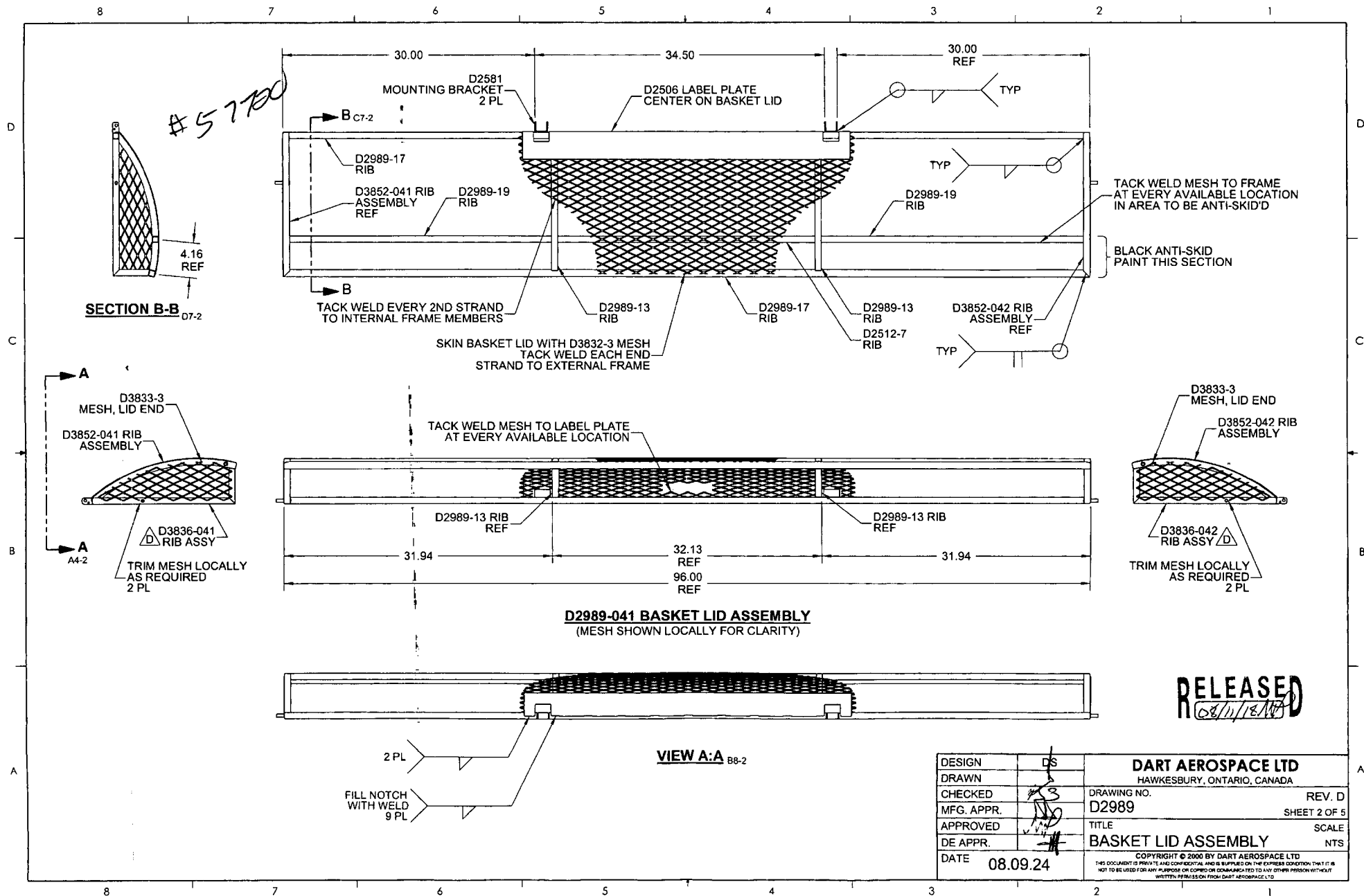
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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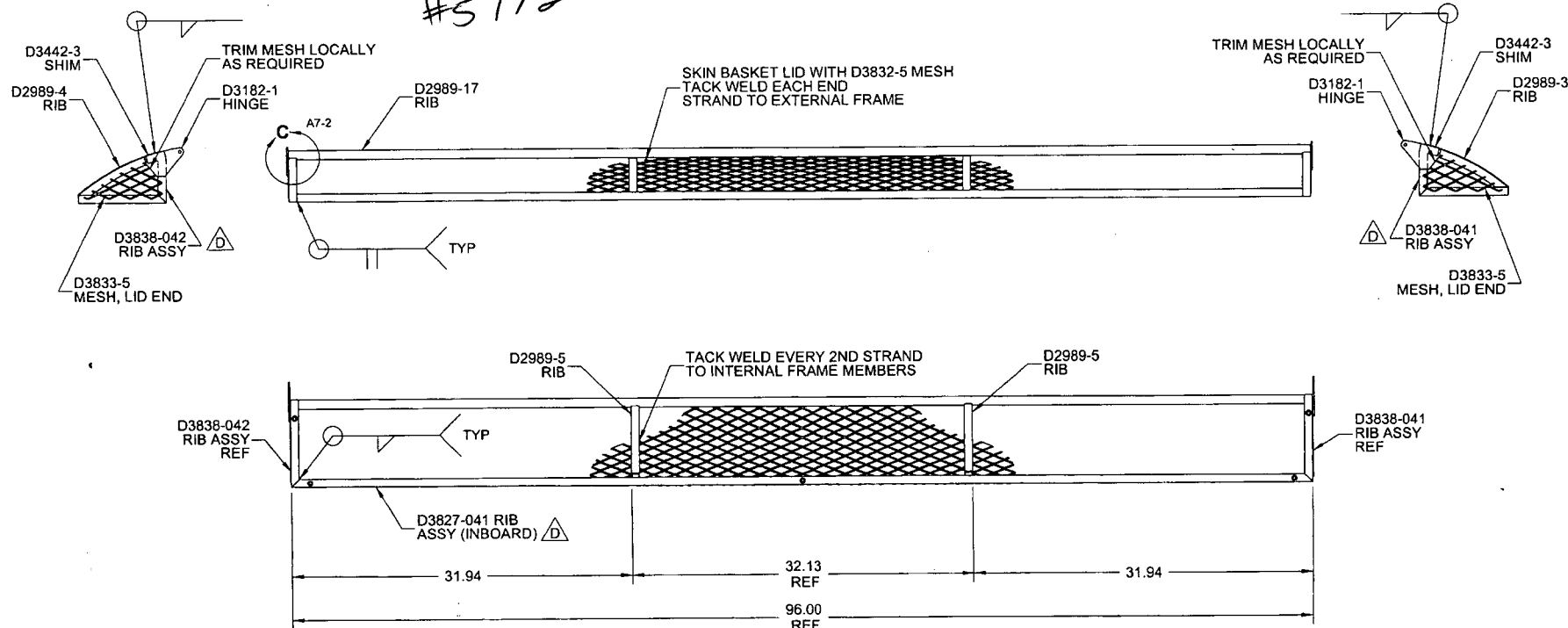
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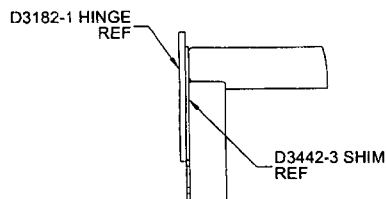
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NOTE: Date & initial all entries

#57720



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



DETAIL C D7-2
TYP, SCALE 4X

RELEASED
08/11/18

| | | | |
|--|--------------------|-----------------------------|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 3 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | BASKET LID ASSEMBLY | |
| DATE | 08.09.24 | NTS | |
| COPYRIGHT © 2000 BY DART AEROSPACE LTD | | | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

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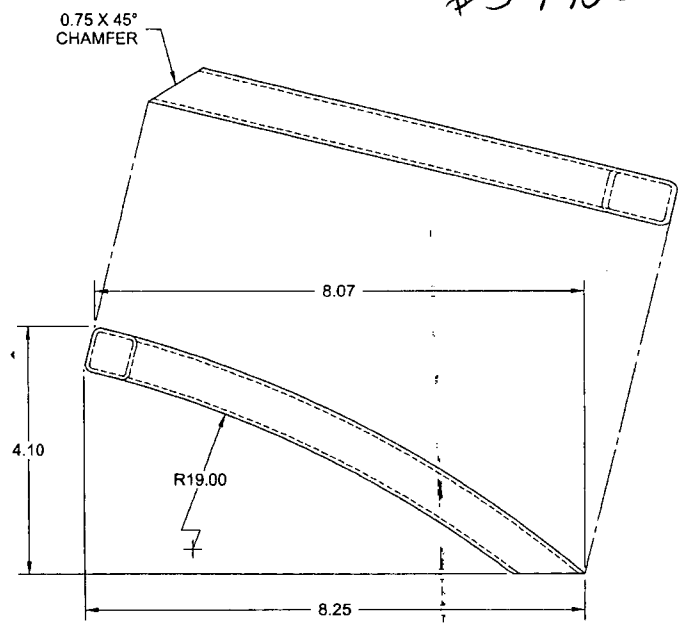
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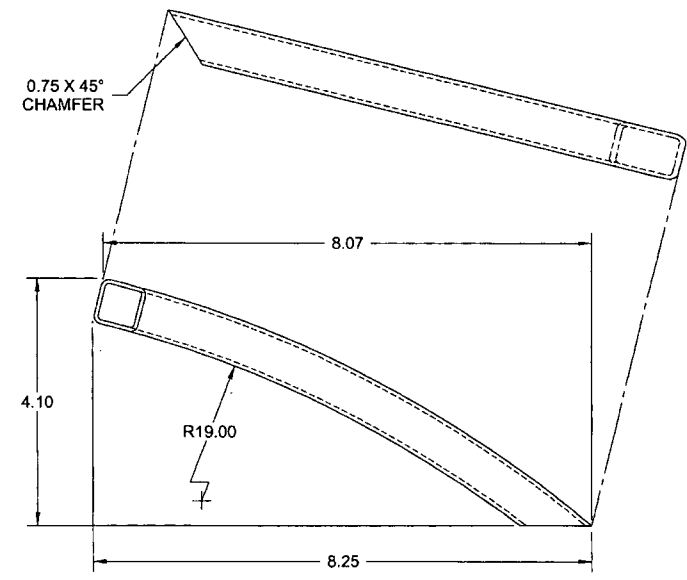
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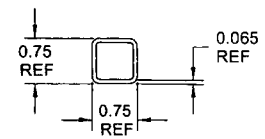
#57720



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

| | | | |
|------------|----------|---|--------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D2989 | REV. D |
| MFG. APPR. | | SHEET 4 OF 5 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY | NTS |
| DATE | 08.09.24 | <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

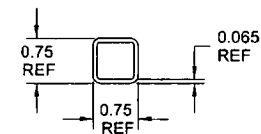
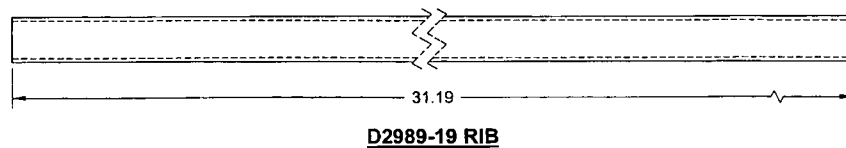
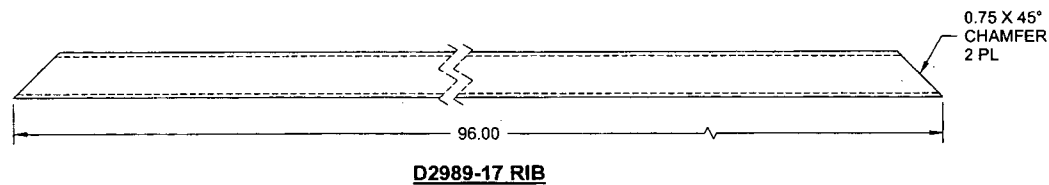
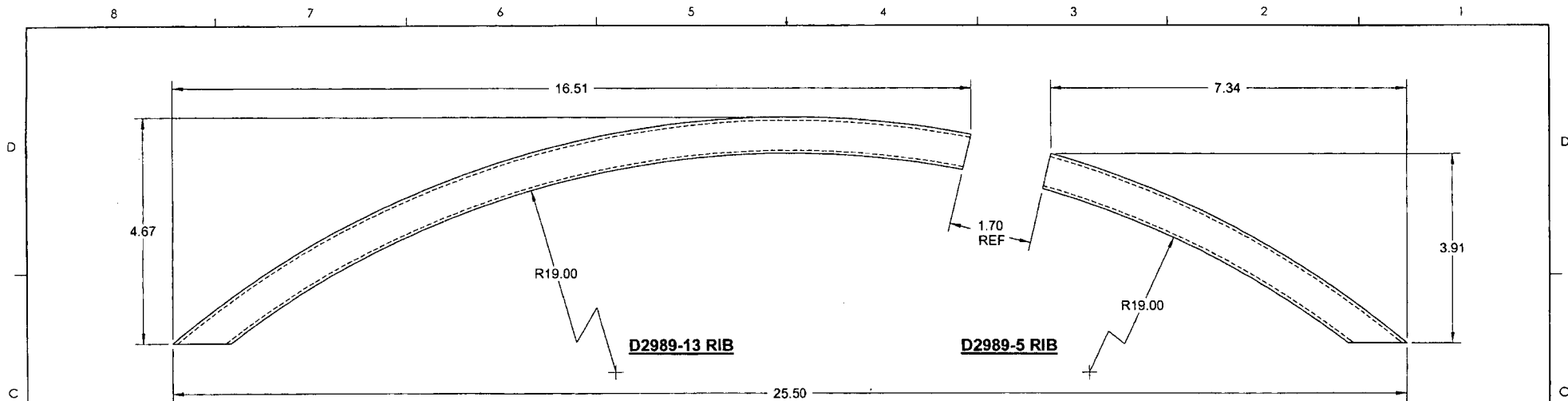
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

#57720



TYPICAL SECTION VIEW

RELEASED
08/11/13

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DS | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY | NTS |
| DATE | 08.09.24 | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries